

Work Order ID 128257

Tuesday, January 13, 2015 1:38:37 PM

128257

Page 1

Item ID: D4632-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Striker Plate

Stop

NS2

Start Date: 1/13/2015 Start Qty: 10.00

10

Cust Item ID:

Required Date: 1/20/2015 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals:

Process Plan: MJSDate: 1501-14

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4632	A								

100

0.00

100

Waterjet

FLOW WATER JET

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg

Dwg Rev: AProg Rev: A

2-Deburr if necessary

304 .050"

(10)

Dec 15/01/15

110

0.00

110

QC

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

Quality Control

(10)

Dec 15/01/15

120

0.00

120

QC

QC8- Inspect parts - second check

Memo

0.00

Quality Control

(10)

DAS
38
9-89

JAN 16 2015

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Page 2

Item ID: D4632-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Striker Plate

Stop ***NS2***

Start Date: 1/13/2015 Start Qty: 10.00

10

Cust Item ID:

Required Date: 1/20/2015 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Form as per dwg
NC BRAKE

0.00

130

Brake NC

Memo

0.00

DAS
30
9-89

10

15/01/20

Brake NC

140

QC5- Inspect part completeness to step on W/O

0.00

140

QC

Memo

0.00

Quality Control

DAS
38
9-89

10

JAN 20 2015

150

Identify as per dwg & Stock Location

0.00

150

Packaging

Memo

0.00

Packaging

DAS
26
9-89

104

JAN 21 2015

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Page 3

Item ID: D4632-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Striker Plate
Start Date: 1/13/2015 Start Qty: 10.00 ***10*** Cust Item ID:
Required Date: 1/20/2015 Req'd Qty: 10.00 ***10*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.00

Quality Control

MLJ

15-01-22

MLJ

15-1-21

Picklist Print

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Page 1

Work Order ID: 128257

128257

Parent Item: D4632-1

D4632-1

Parent Item Name: Striker Plate

Start Date: 1/13/2015

Required Date: 1/20/2015

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP REV:A 12.05.22 NEW ISSUE DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304S18GA

Purchased

No

100

sf

349.2443

0.05

1

M304S18GA

304/316 .050 Sheet

DC 15/01/16

Location

Loc Qty

Loc Code

MAT020

349.2443

124572

23

125552

22

M126647

24.6112

M128254

22.1607

M128435

27

M128864

33

M129530

55

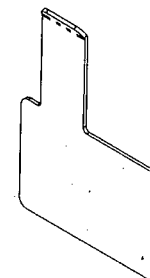
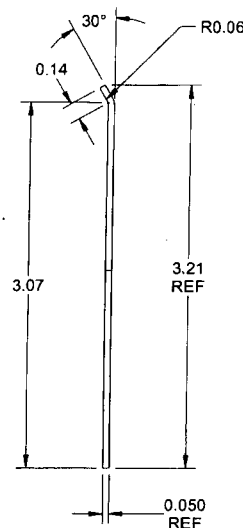
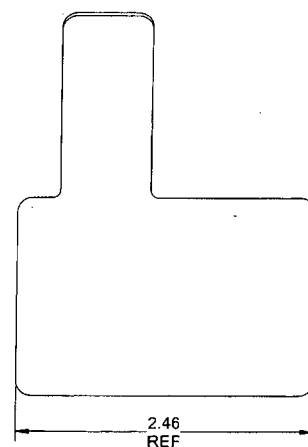
M130345

38

M130923

104.4724

.9444



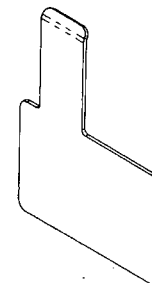
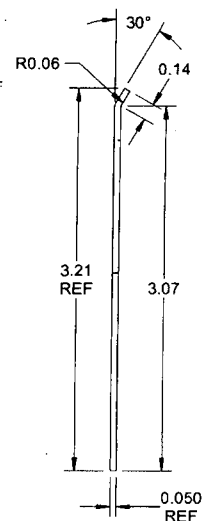
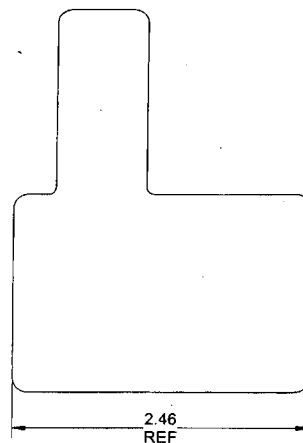
D4632-1 STRIKER PLATE

SUPPLY COPY
 RETURN TO
 OWNER
 FOR REPRODUCTION COPY
 AUTHORITY
 128257_MLJ
 15-01-14

RELEASED
 2012-06-13

- NOTES:**
- 1) MATERIAL: MAKE FROM D4632-1F FLAT PATTERN
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
 - 7) WEIGHT: 0.08 lbs

A NEW ISSUE		RF	12.05.14
REV.		BY	DATE
DESIGN	RF	DART AEROSPACE USA, INC. KENT, WA	
DRAWN	RF		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4632	SHEET 1 OF 3
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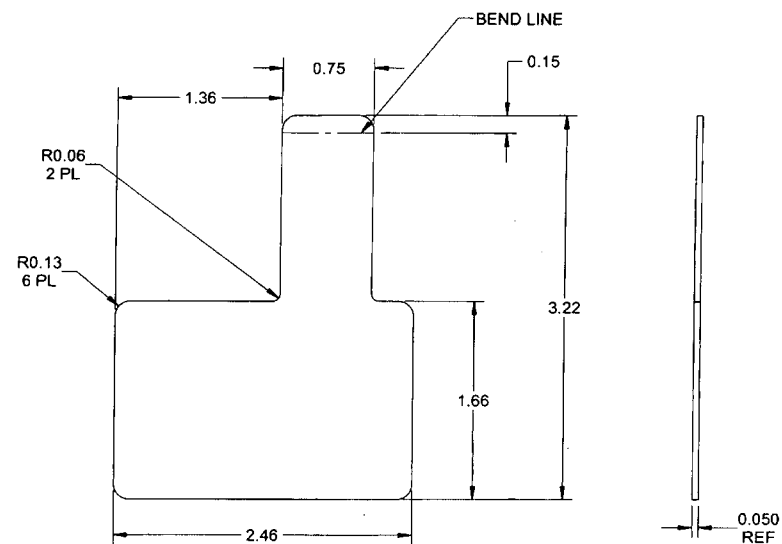
D4632-2 STRIKER PLATE

NOTES:

- 1) MATERIAL: MAKE FROM D4632-1F FLAT PATTERN
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.08 lbs

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2012-06-13
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D4632-1F FLAT PATTERN STRIKER PLATE

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET ANNEALED 2B FINISH
0.050 (18 GAUGE) THICK
PER MIL-S-5059
OR AMS 5513 (304) OR AMS 5524 (316)
OR ASTM A240 OR ASME SA240
REF DART SPEC M304S18GA
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.08 lbs

RELEASE
2012-06-13

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